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D2322**Job Sheet 196842****Part No:** D2322**Job Qty:** 12 pcs**Part Name:** Step Spacer**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 6/21/19**Job Tracking No:****Due Date:** 7/10/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV C IPP Rev:A New Issue 05-11-07 JLM IPP Rev;B Now on Waterjet 06-07-03 JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		7/10/19	0.17	0.66	Waterjet - Flow		02/19/08/21
120	QC 8	12 pcs		7/10/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		AUG 2 1 2019
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - Brake NC - B4B	12 pcs		7/10/19	0.25	0.38	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 -		AUG 2 1

SCRAP

AUG 21 2019

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			B4B		
140 QC 5	12 pcs	7/10/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
150 Handfinish - 1-1 Chemical- B4B	12 pcs	7/10/19	0.00 0.48	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 7	12 pcs	7/10/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	

				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
170	Packaging 3-1 - Stock - B4B	12 pcs	7/10/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
180	QC 21 - SA	12 pcs	7/10/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - 1-Cut as per Dwg D2322 Descriptions: 120 - (QC8- Inspect parts - second check) 130 - Form as per Dwg D2322 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Chemical Conversion Coat per QSI005 4.1) 160 - (QC7-Inspect Chemical Conversion Coat) 170 - (Identify as per dwg & Stock Location: _____) LOCATION : GA 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M2024T3S.040	2024-T3 .040 Sheet	2.4360 sf (.203 ea)	100-Waterjet - Flow - 1	S191572	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.040	2	263	0
Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type
1	Step Spacer	0.250Inches $\pm$ 0.005	0.255 0.245	
2	Step Spacer	4.178Inches $\pm$ 0.005	4.183 4.173	
3	Step Spacer	4.428Inches $\pm$ 0.010	4.438 4.418	
4	Step Spacer	0.250Inches $\pm$ 0.005	0.255 0.245	
5	Step Spacer	6.520Inches $\pm$ 0.010	6.530 6.510	
6	Step Spacer	0.128Inches + 0.005 - 0.000	0.133 0.128	Diameter
7	Step Spacer	0.125Inches $\pm$ 0.010	0.135 0.115	Radius

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

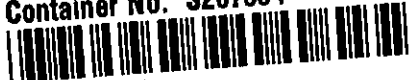
NCR No.

Route update only

Job: 196842		DISPOSITION		DEPARTMENT/PROCESS			
Part No. D2322		Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	
		Scrap ☒	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Water Jet ☐	
		Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐	
						Quality ☐	
Date : AUG 21 2019	Sequence #: 140 QCS	QTY Affected : 21/21			MRB (QSI042)		
Description Work Order Deviation		Disposition			INSP 12 P 19/8/21		
3,400" READS 3,344 - 3,351 +0.010"		SCRAP			Completed By		
					Lead hand / Supervisor		
DAS 68 1-89					QC / QA Coordinator DAS 68 9-89 AUG 21 2019		
Root Cause	FAULT CATEGORY						
Operator ☒	☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong			
Manufacturing Process ☐	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance			
Equip/Tooling ☐	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing			
Handling/Presservation ☐	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish			
Material ☐	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing			
Product Improvement ☐	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread			
Process Improvement ☐	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up				
Human Factors ☐	Other/Details:						



Container No: S207664



Part: D2322

Job No: 196842

Serial No/Batch: S207664

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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